

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023149**Date Inspected:** 30-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

CWI Inspector: Mr. Bao Qian

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. This QA Inspector observed the following:

OBG Trial Assembly

This QA Inspector observed ZPMC welder Mr. Zhao Guanglin, stencil 044779 used shielded metal arc welding procedure WPS-345-SMAW-4G(4F)-FCM-Repair-1 to make critical weld repairs to the underside of OBG segment 14E bottom plate. ZPMC QC informed this QA Inspector that weld repair document B-CWR-2944 documents repairs of this bottom plate where temporary welds had been removed. This QA Inspector observed a welding current of approximately 185 amperes (amps), the base materials were preheated with a torch and Mr. Zhao Guanglin appeared to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

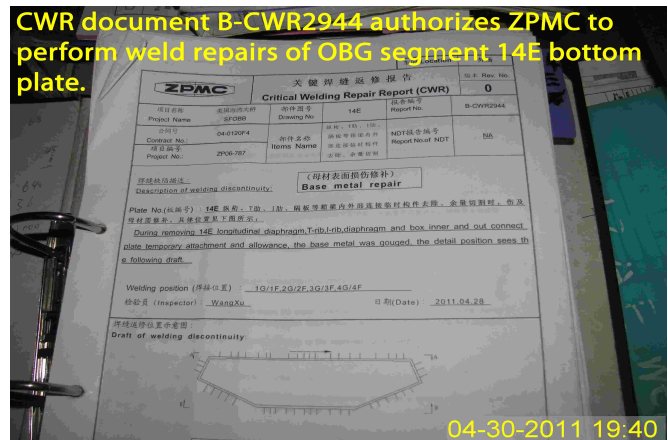
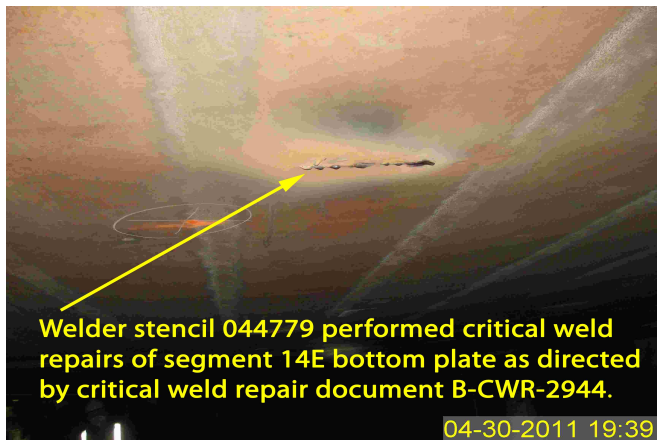
This QA Inspector observed ZPMC welder Mr. Yang Yunfeng, stencil 215553 used shielded metal arc welding procedure WPS-345-SMAW-4G(4F)-FCM-Repair-1 to make weld repairs to weld SEG3019AL-003. ZPMC QC informed this QA Inspector that the weld repair documents this weld had been ultrasonically rejected, reference

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B-787-UT-19158. This QA Inspector observed a welding current of approximately 135 amps, the base materials were preheated with a torch and Mr. Yang Yunfeng appeared to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

This Quality Assurance Inspector performed documentation review of the NWIT system utilized by Caltrans METS. This QA Inspector has identified the Non-Destructive Testing (NDT) for each NWIT performed on the SFOBB in China at ZPMC facility. This includes UT, MT, and RT for each NDT Inspector. This information once it is compiled is sent to the corresponding Inspector and his/her Lead Inspector for further documentation and review.



Summary of Conversations:

See Above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey +8615000026784, who represents the Office of Structural Materials for your project.

Inspected By: Dawson,Paul

Quality Assurance Inspector

Reviewed By: Riley,Ken

QA Reviewer